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Amendments to the Claims:

This listing of claims replaces all prior versions, and listings, of claims in the application:

1. (currently amended) A drilling bar for forming a bore in an extended kelly valve, said bar comprising a first set of cutter heads spaced about a first diameter of said bar and a second set of cutter heads spaced about a second and larger diameter of said bar, and a spade drill located at a leading end of said drilling bar.

2. (currently amended) A drilling bar as defined in claim 1 wherein the cutter heads of each set are diametrically opposite from each other for balancing forces upon said drilling bar, said drilling bar having a diameter nearly as large as the diameter of said bore.

3. (currently amended) A method of forming a bore of [[a]] an elongated kelly valve, said method comprising the steps of providing [[a]] an elongated drill bar having a first set of cutter heads spaced about a first diameter of said bar and a second set of cutter heads spaced about a second and larger diameter of said bar and locating a spade drill at a leading end of the drill bar, said method including the further step of causing relative rotation between said valve and said drill bar for forming a stepped bore in said valve in a single cycle.

4. (currently amended) A method as defined in claim 3 including the step of locating the cutter heads of each set diametrically opposite from each other for balancing forces upon said drilling bar.